

Date: Tuesday, 3/20/2007 2:36:02 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE BILLET
Job Number	: 31386-1		
Estimate Number	: 10032		
P.O. Number	: N/A	Part Number	: D6101001
This Issue	: 3/20/2007 S.O. No. : N/A	Drawing Number	: D6101 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 25345	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 6/1/2007
Checked & Approved By	: <u>7/07.03.20</u>	Qty:	<u>120</u> Um: Each
Comment	: Est. B. 01.05.04 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 3385CL07/03/22

a) Description: Alluminum billet

b) 6.00" x 6.250" x 2.00" thick

c) Tolerance on length are +0.025"/-0.000" AE +/- 0.008"

d) Grain direction along 6.00" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

61
120

2.0

D6101001P

7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 120.0000 Each(s)
 7075-T7351 2X6X6.25

61

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

07/06/12 61

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D

07/06/19 61

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/04/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 2:36:02 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 31386

Part Number: D6101001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

mk 07/06/19

(67)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

20/06/19

Job Completion



W 07.06.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

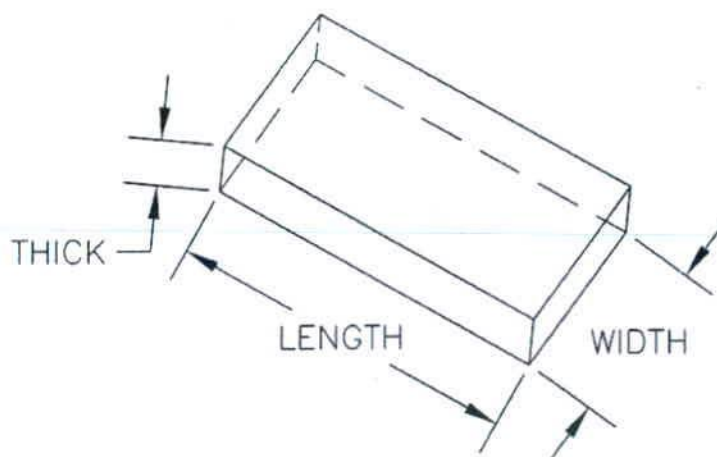
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED [Signature]	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 [Signature]



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

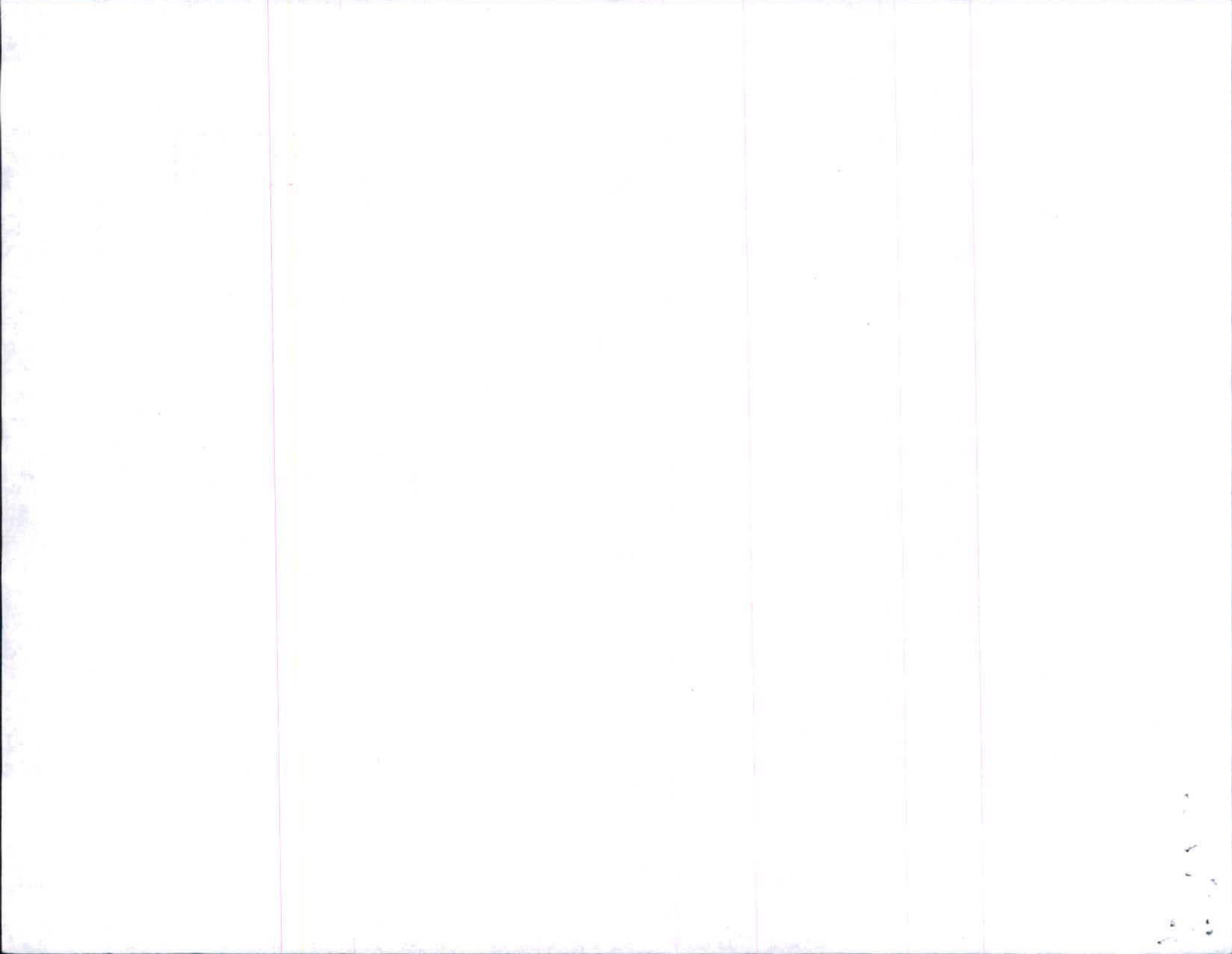
ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 31386

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



CHATEUR-PURCHASING AGENT LINDA LACELLE VRE A-SHIP TO:		NO. COM. CLIENT-CUST. ORD. NO. 3385		COMPT-ACCT. VEND. SLS TERR. EXPEDIE PAR-SHIP VIA 91037 200 40 CABANG (RED) MIDLAND		11 JUN 2007 552417	
TELEPHONE 613 632-3336		H/C TAXE NO. COM ORD 9 0 1		REGION LIVRAISON-DEL ZONE F.A.B.-F.O.B. C/C		PREPAID	
VENDU A-SOLD TO: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY		ON K6A 1K7		INFORMATION CREDIT-CREDIT INFORMATION		ROUTE 01*NL-05/3 31-NL-06/0	
INSTRUCTIONS/LIVRAISON-DELIVERY INO-E55608		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)			
SCRIPTION - ITEM 1 2.0000 PLATE 7075-T7351 ALUM 6.25" X 6.00"		BLACK W/RED STRIPE		QTE/UNITE COM-ORDERED 60 PCS PCS		POIDS COM.-WT. ORDERED 455	
CERTIFICATE OF CONFORMANCE A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon. A.M. Castle & Co. (Canada) Inc.		INSTRUCTIONS TOL: +.025" / -.000" THICKNESS TOL.: +.030" / -.000" GRAIN TO RUN ALONG 6.00" PRIOR DIST/ORD: 01 935034		COULEE INFO-HEAT INFO QTE-QTY 337471		BALLOTS-BUNDLES 1 60	
WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.				INSTRUCTIONS (CONT'D.) 60x6.25x6.000"		FORME-SHAPE I.A.C. 4	
SCRIPTION - ITEM 2 .0000 PLATE 7075-T7351 ALUM 6.25" X 7.875"		BLACK W/RED STRIPE		QTE/UNITE COM-ORDERED 60 PCS PCS		POIDS COM.-WT. ORDERED 597	
TERMS AND CONDITIONS OF SALE SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE		INSTRUCTIONS TOL: +.025" / -.000" THICKNESS TOL.: +.030" / -.000" GRAIN TO RUN ALONG 7.875" PRIOR DIST/ORD: 01 935034 Z BOXES		COULEE INFO-HEAT INFO QTE-QTY 337471		BALLOTS-BUNDLES 1 60	
				INSTRUCTIONS (CONT'D.) 60x6.25x7.875"		FORME-SHAPE I.A.C. 4	
SCRIPTION - ITEM 3 EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY CEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF CH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN DAYS WHEN CREDIT IS REQUESTED.		INSTRUCTIONS		COULEE INFO-HEAT INFO QTE-QTY		QTE/UNITE COM-ORDERED 60 PCS PCS	
1 (LETTRE MOULEE)-NAME (PRINT ONLY)				INSTRUCTIONS (CONT'D.)		BALLOTS-BUNDLES 1 60	
U PAR-RECEIVED BY						FORME-SHAPE I.A.C.	
DATE REC'D DATE RECEIVED						POIDS COM.-WT. ORDERED 597	
						POIDS EXP.-WT. SHIPPED 597	
						ENT-WH	
						ENT-WHSE	

FEVILLE D'EMBALLAGE - PACKING SLIP
END

ALCAN
ROLLED PRODUCTS

CERTIFIED TEST REPORT

RAVENSWOOD, WV 26164 USA

A M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL

60131

A M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL

60131

A M CASTLE 974503 1512 INCLUSION SERIAL#: 20070430974503 PAGE 2 OF 2

CUSTOMER PURCHASE ORDER NO. & ITEM				ALCAN ORDER NO.	
01-83993				113-581105	
ALLOY	CLAD	TEMPER	GAUGE	WIDTH	LENGTH
7075	00	T7351	2.00000	48.500	144.500
ITEM ORDERED					
DIST. AEROSPACE/MILITARY SPEC PLATE, SAWED MILL					
CUSTOMER SPECIFICATION					
AMS-QQ-A-250/12					
PART NUMBER			B/L NUMBER	DATE SHIPPED	
			974500	04/30/07	
WEIGHT SHIPPED		NO. OF PIECES		GOVT. CONTRACT NO.	
5.720		4			

CERTIFICATION

"ALCAN Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on ALCAN Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

ALCAN ROLLED PRODUCTS

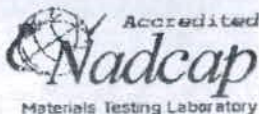
P.O. BOX 88

RAVENSWOOD, WV 26164 USA

LaDonna B. Smith - Quality Manager

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IACS										
			MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX									
ACTUAL CHEMICAL COMPOSITION																			
337471 C SI= 0.06 FE= 0.18 CU= 1.40 MN= 0.05 MG= 2.55 CR= 0.19 ZN= 5.63 TI= 0.07 OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER																			
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW.																			
CHEMISTRY BY OES: ARKSPARK																			
CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT.																			
WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399.																			
WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557.																			
"END OF CERTIFICATION"																			
CHEM COMP	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	EACH MAX	TOTAL MAX
		SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																			



ALCAN
ROLLED PRODUCTS

CERTIFIED TEST REPORT

RAVENSWOOD, WV 26164 USA

SHIP TO

A M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL

60131

SHIP TO

A M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL

60131

A M CASTLE 974503 1512 INCLUSION SERIAL#: 20070430974503 PAGE 1 OF 2

CUSTOMER PURCHASE ORDER NO & ITEM 01-83993				ALCAN ORDER NO 113-581105		CERTIFICATION "ALCAN Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on ALCAN Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." ALCAN ROLLED PRODUCTS P.O. BOX 60 RAVENSWOOD, WV 26164 USA LaDonna B. Smith - Quality Manager
ALLOY 7075	CLAD. 00	TEMPER T7351	GAUGE 2.00000	WIDTH 48.500	LENGTH 144.500	
ITEM ORDERED DIST. AEROSPACE/MILITARY SPEC PLATE, SAWED MILL 6857						
CUSTOMER SPECIFICATION AMS-QQ-A-250/12						
PART NUMBER			B/L NUMBER 974500		DATE SHIPPED 04/30/07	
WEIGHT SHIPPED 5,720		NO. OF PIECES 4		GOVT. CONTRACT NO.		

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IACS										
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.									
337471	LT	2	***** T7351 71.9	73.5	60.8	63.7	***** 11.5	11.5	40.5	41.6									
<p>ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS</p> <p>MIL-STD-2154 100%SONIC TESTED MINUS DEAD ZONE CLASS A</p> <p>ALSO CONFORMS TO AMS 4078E, ASTM B209-04 & ASTM B-594</p> <p>ALSO CONFORMS TO BSS 7055 CL A SONIC</p> <p>CASTLE METALS CORP DATE RCVD 5-4-07 IAC 6857 APPROVED BY <i>lc</i></p>																			
CHEM COMP	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
		SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																			

